



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-107-105

Job Sheet 199745



Part No: RB T102137-107-105

Job Qty: 3 pcs

DAS
21
0.00

Part Name: Strap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Due Date: 9/16/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RB T102137-107 RevG IPP Rev A 17.12.07 New issue DP Verify DD/IPP Rev. B 19.06.07 Material change DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	3 pcs	9/16/19	9/16/19	1.00	0.50	SL-154 - 1	MJP 19/08/31
120	QC 2	3 pcs	9/16/19	9/16/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	MJP 19/08/31
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S210735

Part: RB T102137 - 107 - 105

Job No: 199745

Serial No/Batch: S210735

Revision: G

Inspector:

Print Date:

150 QC 8	3 pcs	9/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	De 19-09-03
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
155 Outsource - 1 - Heat Treat	3 pcs	9/16/19		MEI001-VC A72002	18209-09-04
157 Packaging 2-1 - Receive - B4B	3 pcs	9/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP SEP 11 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	

205 QC 6	3 pcs	9/16/19	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	
210 Packaging 3-1 - Stock - B4B	3 pcs ✓	9/16/19	0.00 0.00	QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	GA-TBD
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	4 pcs	9/16/19	0.00 0.00	QC 21 - SA - 21 ✓	GA-TBD
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

SEP 11 2019

Wed 9-11-2019
Rosales, Oscar

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per folio FB844 FOLIO REV: AA DWG REV: 6 2-
 Descriptions: Debur
 120 - QC2- Inspect parts off machine FAI/FAIB
 150 - QC8- Inspect parts - second check
 155 - 1-Issue P/O; 44422 RC 48-52 2-Bead blast 3--Material type; O1 4- Certificate of Conformity is required
 157 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)
 205 - QC6- All purchased or subcontracted products ***NOTE*** Zinc plating to be done after load test at final assembly.

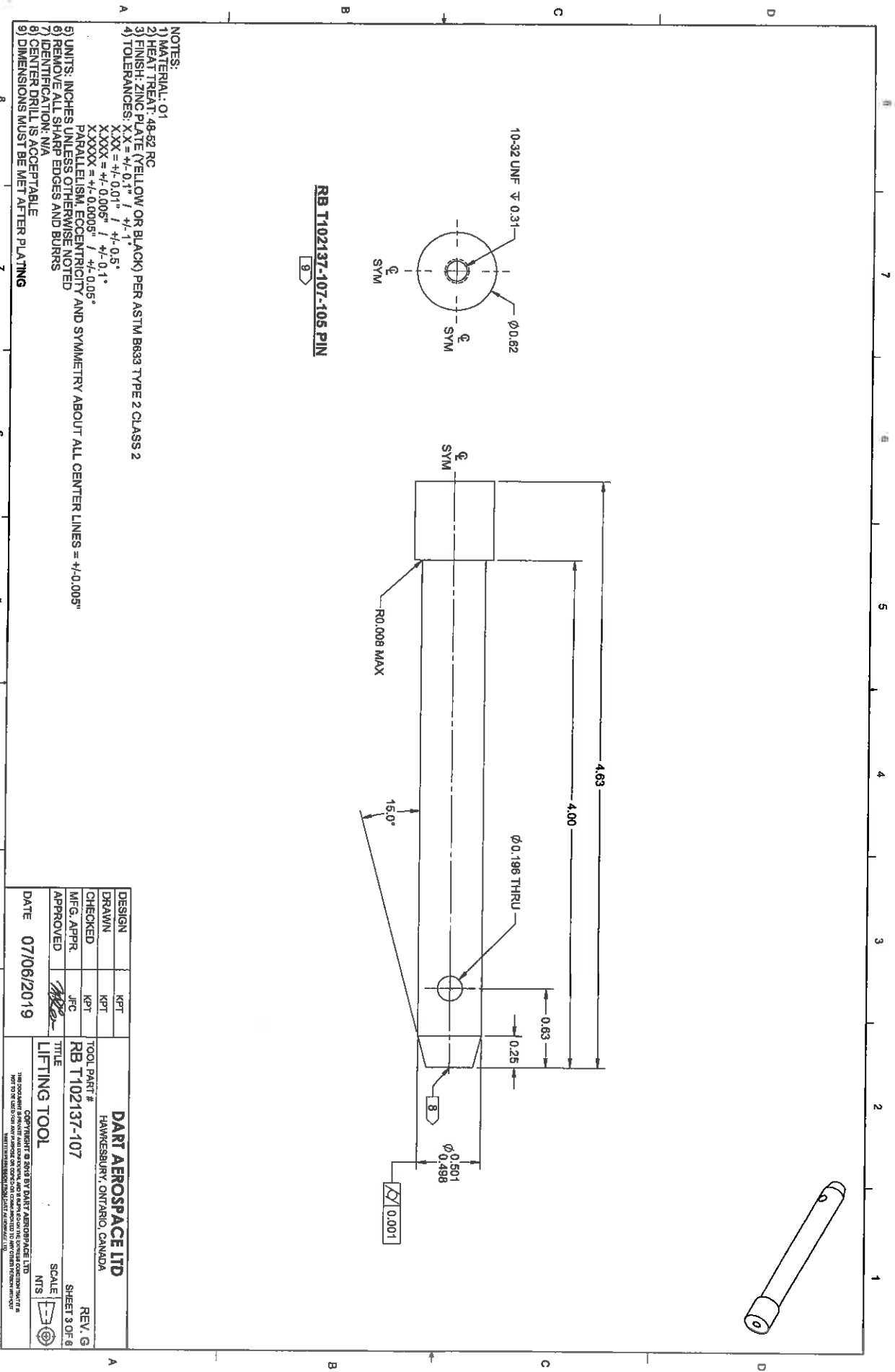
210 - Identify as per dwg & Stock Location:
220 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.625	Tool Steel Round Bar 0.625 dia.	1.2000 ft (.4 ea)	110-SL-154 - 1	5029743

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-O1-R0.625	1	3	0

Part Specifications	
Specifications could not be found.	

Plex 8/30/19 7:30 AM dart.lacelle.linda



- NOTES:
- 1) MATERIAL: 01
 - 2) HEAT TREAT: 48-82 RC
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.3"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE
 - 9) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	JFC	
APPROVED		
DATE	07/06/2019	
TITLE	LIFTING TOOL	
TOOL PART #	RB T102137-107	
REV. G		
SHEET 3 OF 6		
SCALE	NTS	
DATE	07/06/2019	



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044422



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044422

PO Date: 9/4/19

Due Date: 9/13/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198489	RBD29823-5A	Tail Rotor Nut Wrench "D" Model (New Design) HEAT TREATING 1-Issue P/O _____ RC 44-47 Material 4130 2-Bead blast Lightly oil 3- Certificate of Conformity is required	Firmed -		9/13/19	6 pcs	0 pcs	6 pcs	\$14.1666/pcs	\$85.00
2	198346	C10-6	Trunnion (Outsource process - Heat Treat) 1-Issue P/O _____ RC 44-46 2-Bead blast 3-Material type; 4140 Lightly oil 4- Certificate of Conformity is required	Firmed -		9/13/19	9 pcs	0 pcs	9 pcs	\$20.00/pcs	\$180.00
3	199745	RB T102137-107-105	Strap 1-Issue P/O; _____ RC 48-52 2-Bead blast 3-Material type; O1 Lightly oil 4- Certificate of Conformity is required	Firmed -		9/12/19	4 pcs	0 pcs	4 pcs	\$15.4545/pcs	\$61.82

SEP 10 2019

S208692

S210735

SEP 10 2019



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PURCHASE ORDER

POHB044422



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	199742	✓		Firmed	-	9/13/19	7 pcs	✓ 0 pcs	7 pcs	\$15.4545/pcs	\$108.18
Sub Total:							11	0	11		\$170.00
S210698 TX SEP 10 2019 AC											
Grand Total:											\$435.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/9/19 2:50 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To:

1448

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To:

166598

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB044422				

Quantity	Part No. / Part Name / Part Description	Pounds
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4 PCS MATERIAL 01
BEAD BLAST AND HEAT TREAT TO 48-52RC
C OF C, PRT# RBT102137-107-105, JOB# 199745

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

4

Pounds Shipped:

2.00

RECEIVED

SEP 10 2019

DART AEROSPACE LTD.52 cc
bp

9-9-19

Order No.: 169735

Shipped Complete

Quantity Shipped:

4.00

Received By:

Date:

Pounds Shipped:

2.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 09/05/2019

Certification

Date: 09/09/2019

Entry Date: 09/05/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB044422

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
4	4 PCS MATERIAL 01 BEAD BLAST AND HEAT TREAT TO 48-52RC C OF C, PRT# RBT102137-107-105, JOB# 199745	2

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

Results:

Harden ROCKWE 48. 52. 52. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 52 RC AS PER CUSTOMER REQUEST

DAS
81
9-89

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


JOSE GONZALEZ
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD